

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004688**Date Inspected:** 11-Nov-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Chih-Ming**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Corner assemblies**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Steve Hall was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

OBG assembly bay 2

QA issued four incident reports today for the following nonconformances: Cracked tacks on corner assembly CA-029A, freehand thermal cutting slots without engineers approval on corner assembly CA-029A, tack welding temporary knee braces to SPCM material without engineers approval on corner assembly CA-029A and ZPMC Quality Control (QC) Magnetic particle Testing (MT) technicians acceptance of rejectable linear indications on fillet weld joints between urib and external diaphragms on DP-326-002 and DP-461-001.

QA received ZPMC NDT notification # 001389 and performed 10% verification Magnetic particle Testing (MT) on DP-326-002, DP-461-001 and DP-488-001. QA found 3 nonconforming linear toe indications on DP-461-001 and 1 nonconforming linear toe indication on DP-326-002 (see attached photo). All welds tested on DP-488-001 appeared to be in conformance with the contract documents and AWS D1.5 2002.

QA also attempted to perform UT from the same NDT notification on welds identified as SEG-024A-017/018. QA found these weld joints in the east OBG segment. The welds had not been UT'ed by ZPMC today. I spoke with ZPMC QA Mr. Testino Wang concerning these welds and he informed QA that the NDT notification for UT on these welds was an error and no welds had been UT'ed today in assembly bay 2.

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Summary of Conversations:

As mentioned above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Ryan Smith, (858) 232-6799, who represents the Office of Structural Materials for your project.

Inspected By:	Hall,Steven	Quality Assurance Inspector
Reviewed By:	Cuellar,Robert	QA Reviewer
